

Work Order ID 71976

Thursday, July 14, 2011 3:11:01 PM



Page 1

Item ID:	D3531-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket Assembly					
Start Date:	7/14/2011	Start Qty:	5.00			
Required Date:	7/22/2011	Req'd Qty:	5.00			
Reference:						

Approvals:	Process Plan:		Date:	11-07-14	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3531	Rev A								

100
 Small Fab 0.00
 Small Fab Memo 0.00
 Small Fab Assemble as per dwg D3531

110
 QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00
 Quality Control

120
 Black Sandtex(Ref:4.3.5.7) per QS1005 4.3 0.00
 Powdercoat Memo 0.00
 Powder Coating

START TIME: 10:30 OVEN TEMPERATURE:
 FINISH TIME: 11:00

8/5/08/23 (46)

Pho-2

(46)

6X Ø m-hu/or/25

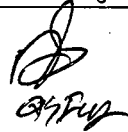
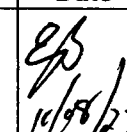
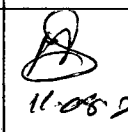
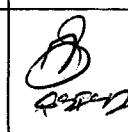
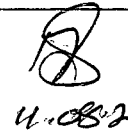
M 113728

3200F

11:00

W/O: 71976		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3531-041 PAR #: N/A Fault Category: Sm. Feb NCR: Yes No DQA: 18 Date: 11.08.29
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 42 Date: 11/08/29

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/08/23	100	1 part is scrap 1 nut was cracked when removed hole came bigger		Scrap - destroy No replace	 11/08/23	 11-08-23	 11-08-23	 11-08-23
		R.C Process Scrap						

NOTE: Date & initial all entries

Work Order ID 71976

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Item ID: D3531-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 7/14/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC3- Inspect Part Finish

0.00



QC Memo

0.00

Quality Control

6 BL 11-8-25

140 Identify as per dwg & Stock Location

0.00



Packaging Memo

0.00

Packaging

SD

60x Sp 11-08-25

150 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

11/8/25

CL1108/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 14, 2011 3:11:08 PM

Page 1

Work Order ID: 71976

Parent Item: D3531-041

Parent Item Name: Bracket Assembly









Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3531-1  Bracket		Manufactured	No			100	Each	0.0000	1	5			
						B 71977		(7K)				7/11/08/23	
D3531-3  Bracket Front Plate		Manufactured	No			100	Each	0.0000	1	5			
						B 71978		(7K)				7/11/08/23	
MS20470AD4-4  Rivet, Universal Head		Purchased	No			100	Each	1,160.000	12	60			
												7/11/08/23	

Location

Loc Qty

Loc Code

ST139

618

117423

618

ST319

542

116188

476

116391

66

1118614 (84K)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

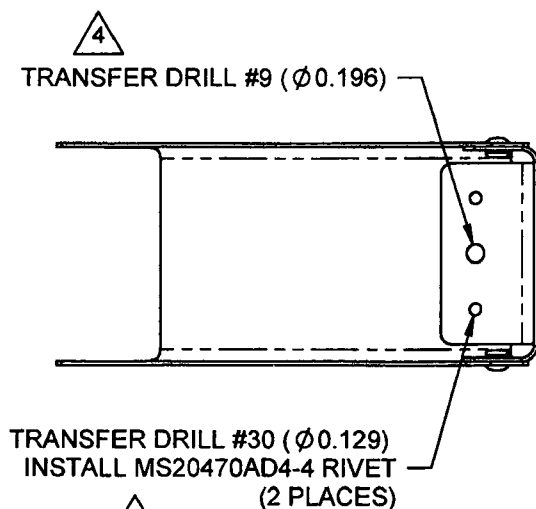
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	

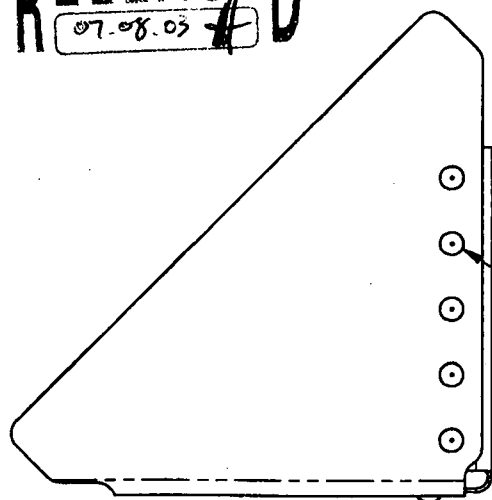


RELEASED
07.08.03

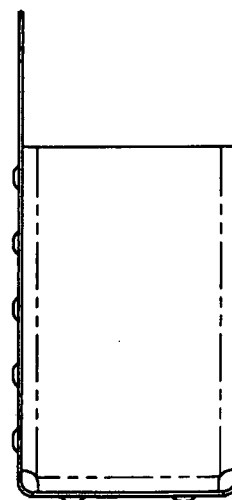
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 11-07-14

D3531-3
BRACKET FRONT PLATE

D3531-1
BRACKET



MS20470AD4-4
(10 PLACES)



D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING
WHITE MARKER ON INSIDE OF BRACKET
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET
THROUGH D3531-3 BRACKET FRONT PLATE
BEFORE FINISHING

PARTS LIST

QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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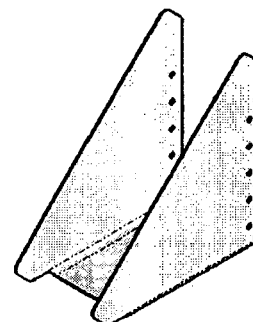
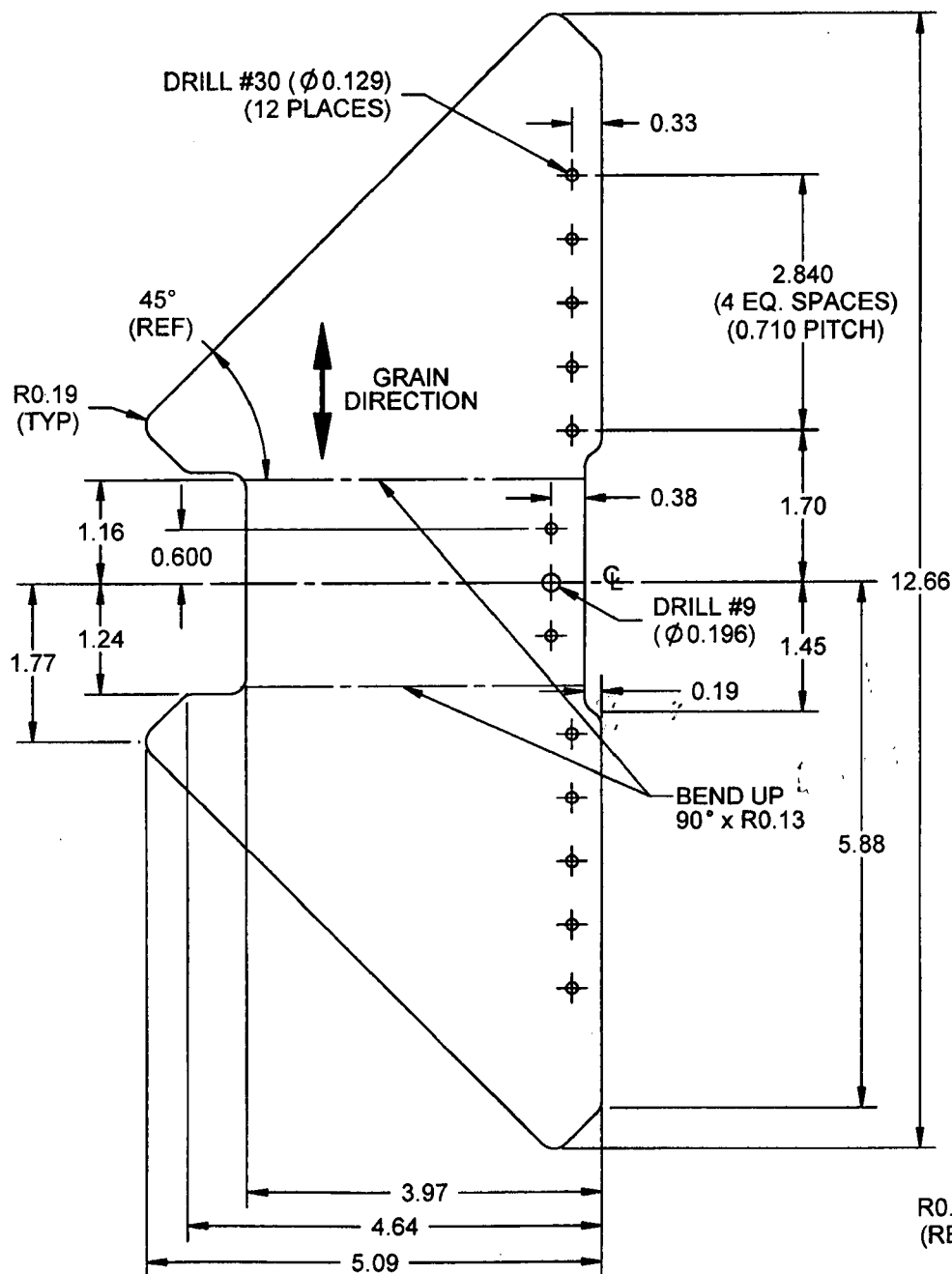
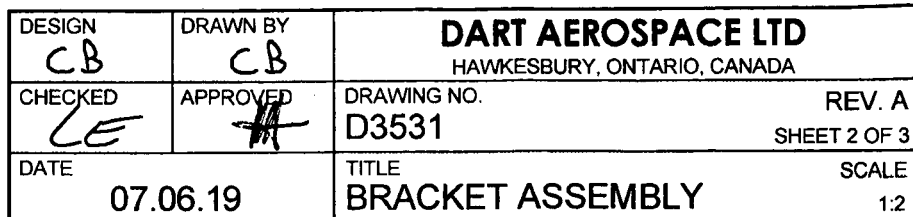
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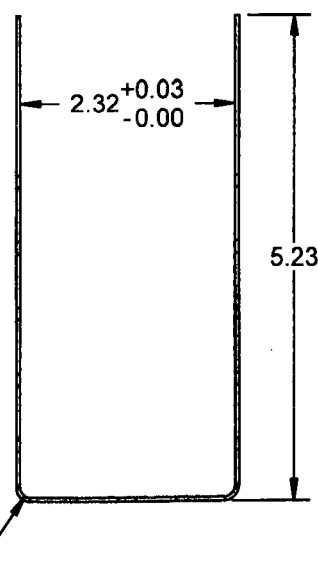
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
07-08-03



D3531-1F FLAT PATTERN

D3531-1 BRACKET

NOTES:

- NOTES:**
- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
 - 6) PART IS SYMMETRIC ABOUT C

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

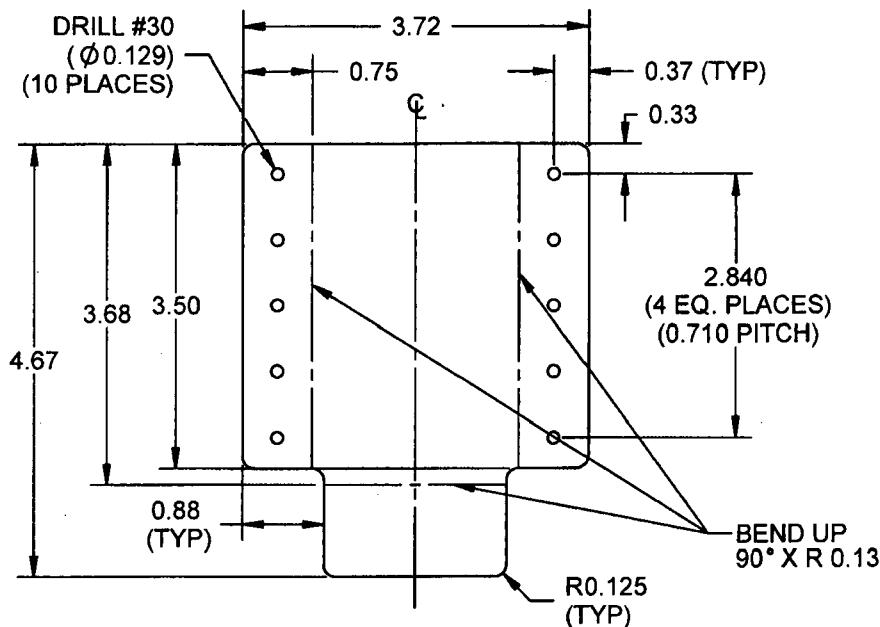
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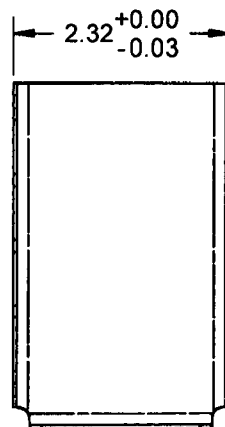
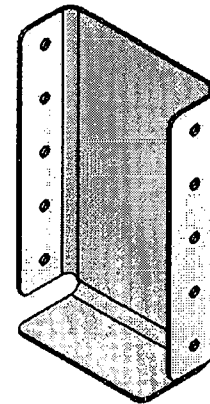


DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>#</i>	DRAWING NO. D3531	REV. A SHEET 3 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2

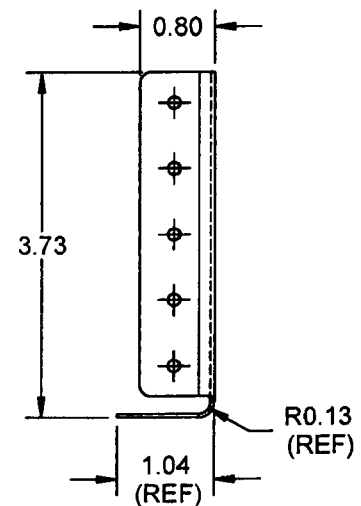


D3531-3F FLAT PATTERN

RELEASED
07.08.03



1976



D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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